

Rush Ship June 10

Work Order ID 133361

\*133361\*

Page 1

Monday, June 08, 2015 8:55:53 AM

Item ID: D4049-11

Accept

\*N900040100\* PRELIMINARY ISSUE

Revision ID: PRELIM

Item Name: Lug

Stop \*NS2\*

Start Date: 6/08/15

Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 6/10/15

Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

1568

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4049

C1 9.11

100

0.00

\*100\*

Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK 2.550" LONG

2 0

DAS  
37  
9-99

15.06.09

110

0.00

\*110\*

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

mill as per dwg and FOLIO FB392

FOLIO REV: AA

DWG REV: C1

2 0

DAS  
37  
9-99

15.06.09

DEBURR

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____		<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>             Skid-tube <input type="checkbox"/>              Machining <input type="checkbox"/>              Thermoforming <input type="checkbox"/>              Large Fab <input type="checkbox"/> </div> <div>             Cross tube <input type="checkbox"/>              Small Fab <input type="checkbox"/>              Finishing <input type="checkbox"/>              Composite <input type="checkbox"/> </div> <div>             Water Jet <input type="checkbox"/>              Prod. Eng. Coord. <input type="checkbox"/>              Rec/Store/Packaging <input type="checkbox"/>              Supplier <input type="checkbox"/> </div> <div>             Engineering <input type="checkbox"/>              Quality <input type="checkbox"/>              Other <input type="checkbox"/> </div> </div>					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By   Lead hand / Supervisor Approval Verification   QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment <input type="checkbox"/>	No Re-verification <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>				
Design <input type="checkbox"/>	Operator <input type="checkbox"/>	Bending <input type="checkbox"/>	Set-up <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>				
Doc/Data <input type="checkbox"/>	Offset/Setup <input type="checkbox"/>	Centre Not Concentric <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>				
Equip/Tooling <input type="checkbox"/>	Supplier <input type="checkbox"/>	Cracks <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Weld <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>				
Handling/Pre <input type="checkbox"/>	Training <input type="checkbox"/>	Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>				
Material <input type="checkbox"/>	Use for Testing <input type="checkbox"/>	Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>	Part Moved <input type="checkbox"/>				
Internal Transport <input type="checkbox"/>	Poor Information <input type="checkbox"/>	Crushing <input type="checkbox"/>	Countersink <input type="checkbox"/>	Off-set <input type="checkbox"/>	Drawing <input type="checkbox"/>				
Tribal Knowledge <input type="checkbox"/>	Rushing <input type="checkbox"/>	Heat Treat <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Finish <input type="checkbox"/>				
LOA <input type="checkbox"/>	Product Improvement <input type="checkbox"/>	Wave/Twist in Tube <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Fit/Function <input type="checkbox"/>	Misread <input type="checkbox"/>				
Substation <input type="checkbox"/>	Process Improvement <input type="checkbox"/>	Marks/Chatter <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Turning Sequence <input type="checkbox"/>				
Past Expiry Date <input type="checkbox"/>	Manufacturing Process <input type="checkbox"/>	OTHER :							
Misidentified <input type="checkbox"/>	Past Due <input type="checkbox"/>								



DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____		<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By   Lead hand / Supervisor Approval Verification   QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment <input type="checkbox"/>	No Re-verification <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>				
Design <input type="checkbox"/>	Operator <input type="checkbox"/>	Bending <input type="checkbox"/>	Set-up <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>				
Doc/Data <input type="checkbox"/>	Offset/Setup <input type="checkbox"/>	Centre Not Concentric <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>				
Equip/Tooling <input type="checkbox"/>	Supplier <input type="checkbox"/>	Cracks <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Weld <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>				
Handling/Pre <input type="checkbox"/>	Training <input type="checkbox"/>	Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>				
Material <input type="checkbox"/>	Use for Testing <input type="checkbox"/>	Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>	Part Moved <input type="checkbox"/>				
Internal Transport <input type="checkbox"/>	Poor Information <input type="checkbox"/>	Crushing <input type="checkbox"/>	Countersink <input type="checkbox"/>	Off-set <input type="checkbox"/>	Drawing <input type="checkbox"/>				
Tribal Knowledge <input type="checkbox"/>	Rushing <input type="checkbox"/>	Heat Treat <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Finish <input type="checkbox"/>				
LOA <input type="checkbox"/>	Product Improvement <input type="checkbox"/>	Wave/Twist in Tube <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Fit/Function <input type="checkbox"/>	Misread <input type="checkbox"/>				
Substation <input type="checkbox"/>	Process Improvement <input type="checkbox"/>	Marks/Chatter <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Turning Sequence <input type="checkbox"/>				
Past Expiry Date <input type="checkbox"/>	Manufacturing Process <input type="checkbox"/>								
Misidentified <input type="checkbox"/>	Past Due <input type="checkbox"/>	OTHER :							

Work Order ID 133361

\*133361\*

Page 3

Monday, June 08, 2015 8:55:53 AM

Item ID: D4049-11 Accept \*N900040100\* Setup Start \*NS1\*  
Revision ID: PRELIM Stop \*NS2\*  
Item Name: Lug  
Start Date: 6/08/15 Start Qty: 2.00 \*2\* Cust Item ID:  
Required Date: 6/10/15 Req'd Qty: 2.00 \*2\* Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21- Final Inspection - Work Order Release	0.00							
*150*									
QC	Memo	0.00							
Quality Control									

15-6-15

POSITIVE RECALL

EFFECTIVE 15-6-8 AUTH

RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____		<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube <input type="checkbox"/></td> <td style="border: none;">Cross tube <input type="checkbox"/></td> <td style="border: none;">Water Jet <input type="checkbox"/></td> <td style="border: none;">Engineering <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Machining <input type="checkbox"/></td> <td style="border: none;">Small Fab <input type="checkbox"/></td> <td style="border: none;">Prod. Eng. Coord. <input type="checkbox"/></td> <td style="border: none;">Quality <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Thermoforming <input type="checkbox"/></td> <td style="border: none;">Finishing <input type="checkbox"/></td> <td style="border: none;">Rec/Store/Packaging <input type="checkbox"/></td> <td style="border: none;">Other <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Large Fab <input type="checkbox"/></td> <td style="border: none;">Composite <input type="checkbox"/></td> <td style="border: none;">Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Cross tube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Cross tube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>																						
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>																						
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>																						
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition																					
								Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment <input type="checkbox"/> Design <input type="checkbox"/> Doc/Data <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Handling/Pre <input type="checkbox"/> Material <input type="checkbox"/> Internal Transport <input type="checkbox"/> Tribal Knowledge <input type="checkbox"/> LOA <input type="checkbox"/> Substation <input type="checkbox"/> Past Expiry Date <input type="checkbox"/> Misidentified <input type="checkbox"/>	No Re-verification <input type="checkbox"/> Operator <input type="checkbox"/> Offset/Setup <input type="checkbox"/> Supplier <input type="checkbox"/> Training <input type="checkbox"/> Use for Testing <input type="checkbox"/> Poor Information <input type="checkbox"/> Rushing <input type="checkbox"/> Product Improvement <input type="checkbox"/> Process Improvement <input type="checkbox"/> Manufacturing Process <input type="checkbox"/> Past Due <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Wave/Twist in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/> Set-up <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Drill Holes <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Off-set <input type="checkbox"/> Mislabelled <input type="checkbox"/> Fit/Function <input type="checkbox"/> Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Misread <input type="checkbox"/> Turning Sequence <input type="checkbox"/>	OTHER : _____																			

# Picklist Print

Page 1

Monday, June 08, 2015 8:55:58 AM

Work Order ID: 133361

**\*133361\***

Parent Item: D4049-11

**\*D4049-11\***

Parent Item Name: Lug

Start Date: 6/08/15

Required Date: 6/10/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 15.06.05 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.500X1.500		Purchased		No			f	22.8490		1			
<b>*M304B0 500X1 500*</b>										<b>**</b>			
304 BAR .500 x 1.50													

**DAS**  
**37**  
**9.89 15.06.09**

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT009	22.849	
113762	13.333	
116135	9.516	

500 ft.

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

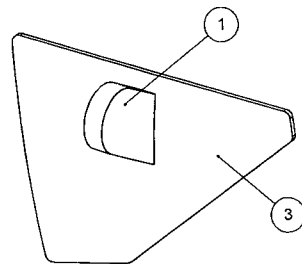
QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

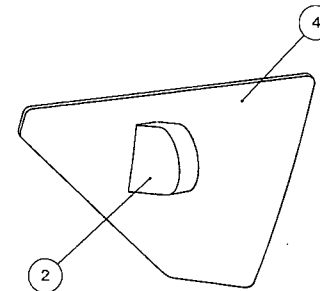
Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
<b>Root Cause</b> <div style="display: flex; justify-content: space-between;"> <div>           Environment <input type="checkbox"/>            Design <input type="checkbox"/>            Doc/Data <input type="checkbox"/>            Equip/Tooling <input type="checkbox"/>            Handling/Pre <input type="checkbox"/>            Material <input type="checkbox"/>            Internal Transport <input type="checkbox"/>            Tribal Knowledge <input type="checkbox"/>            LOA <input type="checkbox"/>            Substation <input type="checkbox"/>            Past Expiry Date <input type="checkbox"/>            Misidentified <input type="checkbox"/> </div> <div>           No Re-verification <input type="checkbox"/>            Operator <input type="checkbox"/>            Offset/Setup <input type="checkbox"/>            Supplier <input type="checkbox"/>            Training <input type="checkbox"/>            Use for Testing <input type="checkbox"/>            Poor Information <input type="checkbox"/>            Rushing <input type="checkbox"/>            Product Improvement <input type="checkbox"/>            Process Improvement <input type="checkbox"/>            Manufacturing Process <input type="checkbox"/>            Past Due <input type="checkbox"/> </div> </div>		<b>FAULT CATEGORY</b> <div style="display: flex; justify-content: space-between;"> <div>           Pressure/Forced <input type="checkbox"/>            Bending <input type="checkbox"/>            Centre Not Concentric <input type="checkbox"/>            Cracks <input type="checkbox"/>            Crimp/Kink/Ripple/Wave <input type="checkbox"/>            Cuffs <input type="checkbox"/>            Crushing <input type="checkbox"/>            Heat Treat <input type="checkbox"/>            Wave/Twist in Tube <input type="checkbox"/>            Marks/Chatter <input type="checkbox"/> </div> <div>           Temperature/Cure <input type="checkbox"/>            Set-up <input type="checkbox"/>            BOM/Route <input type="checkbox"/>            Broken/Damage/Defect <input type="checkbox"/>            Inspection Incomplete/Unqualified <input type="checkbox"/>            Contamination <input type="checkbox"/>            Countersink <input type="checkbox"/>            Cut Too Short <input type="checkbox"/>            Instructions Incomplete/Unclear <input type="checkbox"/>            Drill Holes <input type="checkbox"/> </div> <div>           Power Loss/Surge <input type="checkbox"/>            Folio/Program <input type="checkbox"/>            Grain <input type="checkbox"/>            Weld <input type="checkbox"/>            Wrong Stock Pulled <input type="checkbox"/>            Out of Sequence <input type="checkbox"/>            Off-set <input type="checkbox"/>            Mislabeled <input type="checkbox"/>            Fit/Function <input type="checkbox"/>            Misaligned/off center <input type="checkbox"/> </div> <div>           Positioned Wrong <input type="checkbox"/>            Outside Dimensions <input type="checkbox"/>            Over/Under tolerance <input type="checkbox"/>            Part Incorrect <input type="checkbox"/>            Part Lost/Missing <input type="checkbox"/>            Part Moved <input type="checkbox"/>            Drawing <input type="checkbox"/>            Finish <input type="checkbox"/>            Misread <input type="checkbox"/>            Turning Sequence <input type="checkbox"/> </div> </div>			
OTHER : _____					



ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
	X		D4049-041	MOUNTING LUG ASSY, LH
		X	D4049-042	MOUNTING LUG ASSY, RH
1	1		D4049-1	LUG
2		1	D4049-2	LUG
3	1		D4049-3	MOUNTING PLATE, LH
4		1	D4049-4	MOUNTING PLATE, RH



**D4049-041 MOUNTING LUG ASSY, LH**

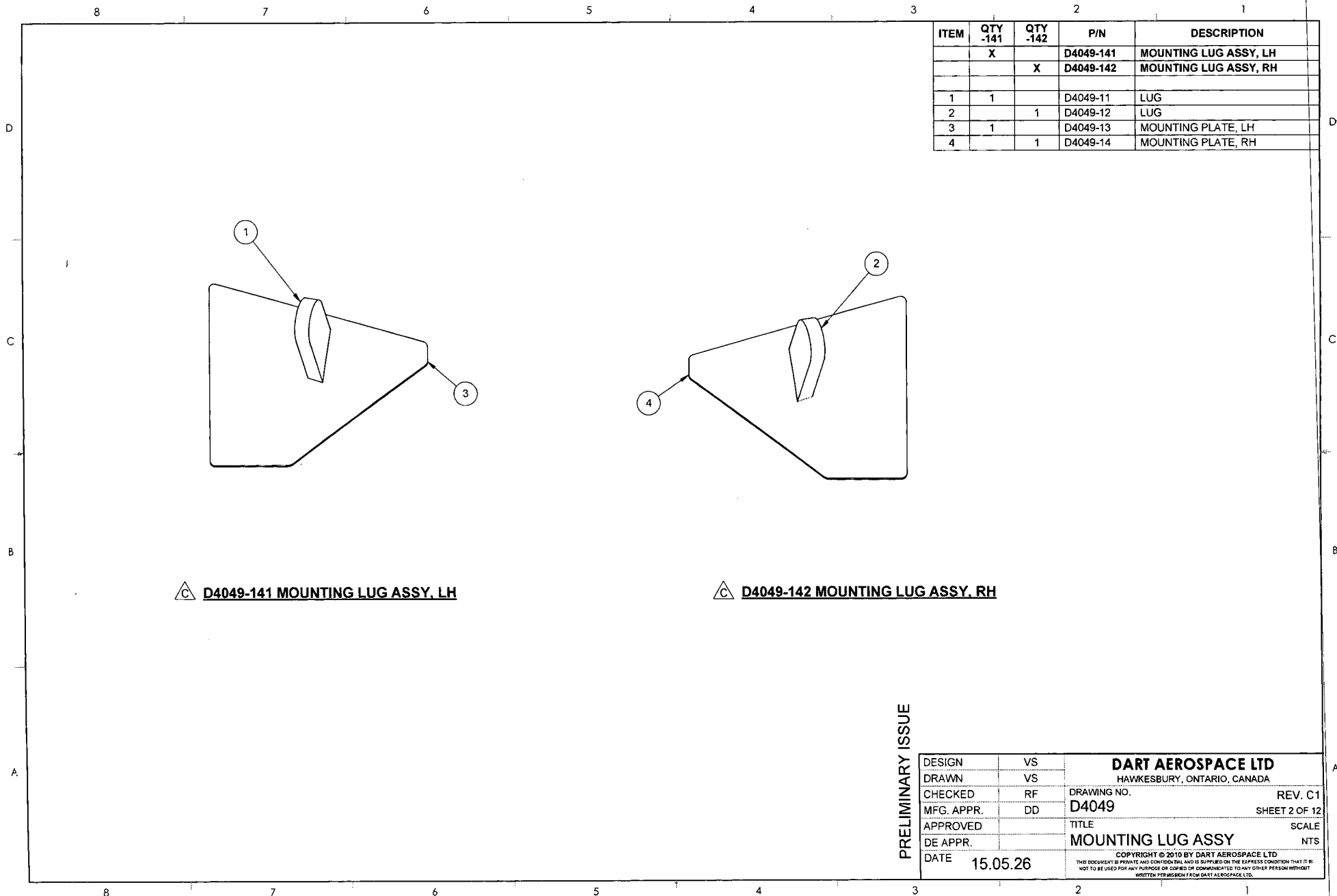


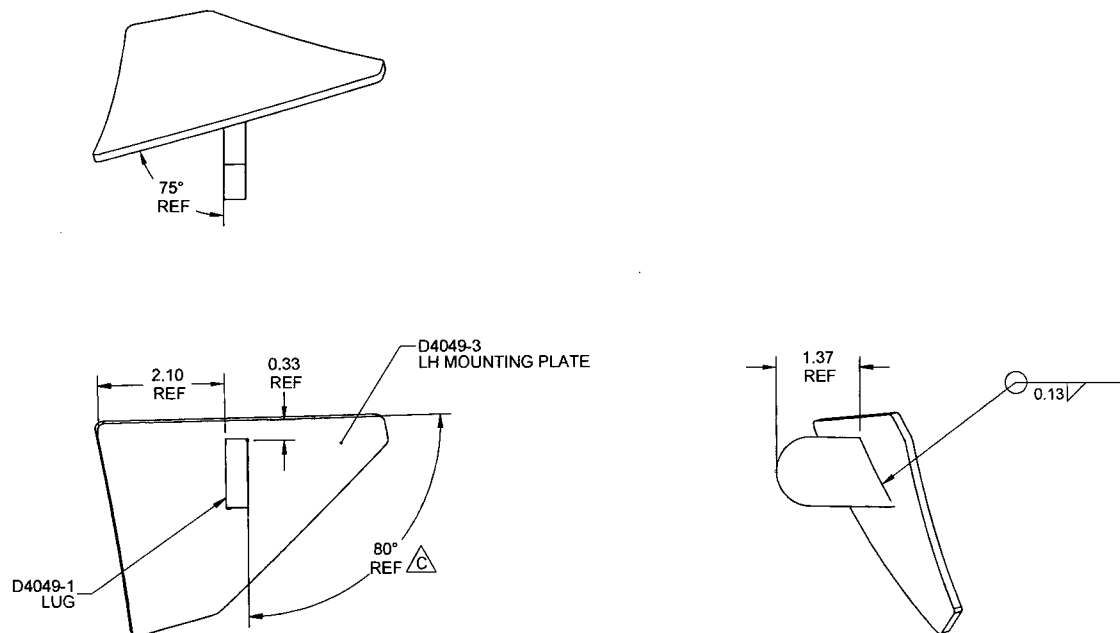
**D4049-042 MOUNTING LUG ASSY, RH**

*Handwritten:* DS-6.8  
133361

PRELIMINARY ISSUE

C	ADD -141/-142; ZN B4-3, B8-3, B4-6, B3-5, ADD -11/-12; ZN A4-10, B2-11, ADD -13/-14; ZN C1-12, A1-12, REVISE DIM; ZN B5-3, B4-4, ADD -2 VIEW; ZN B2-7	VS	15.05.26
B	80° WAS 83°, 0.33 WAS 0.55 & 2.10 WAS 2.50 (ZN C6-2)	RF	10.03.19
A	NEW ISSUE	RF	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	<b>DART AEROSPACE LTD</b>	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C1
MFG. APPR.	DD	D4049	SHEET 1 OF 12
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG ASSY	NTS
DATE	15.05.26	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	





**D4049-041 MOUNTING LUG ASSY, LH**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.64 lbs
- 8) WELD PER DART QSI 004 USING WELDING JIG DT9584

PRELIMINARY ISSUE

DESIGN	VS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. C1
MFG. APPR.	DD	<b>D4049</b>	SHEET 3 OF 12
APPROVED		TITLE	SCALE
DE APPR.		<b>MOUNTING LUG ASSY</b>	NTS
DATE	15.05.26	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

D

D

C

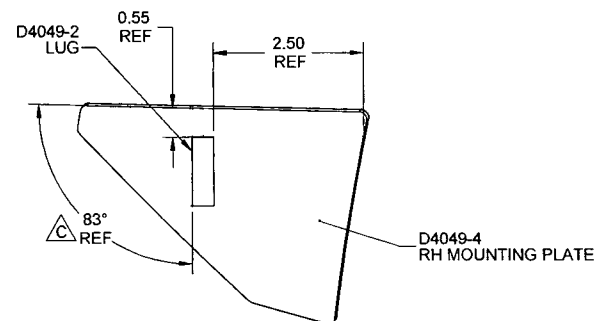
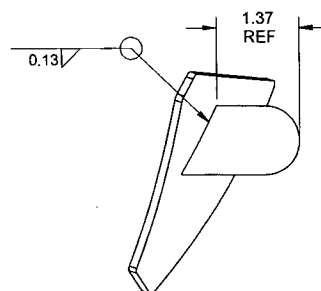
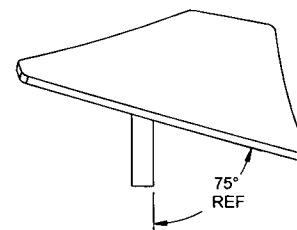
C

B

B

A

A



**D4049-042 MOUNTING LUG ASSY. RH**

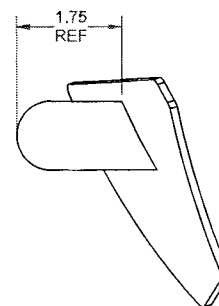
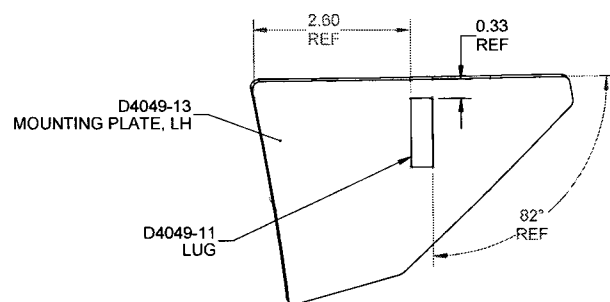
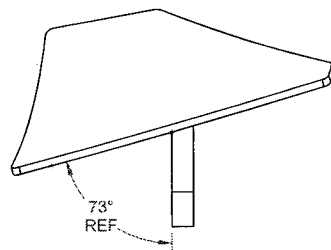
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.64 lbs
- 8) WELD PER DART QSI 004 USING WELDING JIG DT9583

PRELIMINARY ISSUE

DESIGN	VS	<b>DART AEROSPACE LTD</b>	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D4049	SHEET 4 OF 1
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG ASSY	NTS
DATE	15.05.26	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1



8 D4049-141 MOUNTING LUG ASSY. LH C

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-141" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.77 lbs
- 8) WELD PER DART QSI 004 USING WELDING JIG DTXXXX

PRELIMINARY ISSUE

DESIGN	VS	<b>DART AEROSPACE LTD</b>	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C1
MFG. APPR.	DD	<b>D4049</b>	SHEET 5 OF 12
APPROVED		TITLE	SCALE
DE APPR.		<b>MOUNTING LUG ASSY</b>	NTS
DATE	15.05.26	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

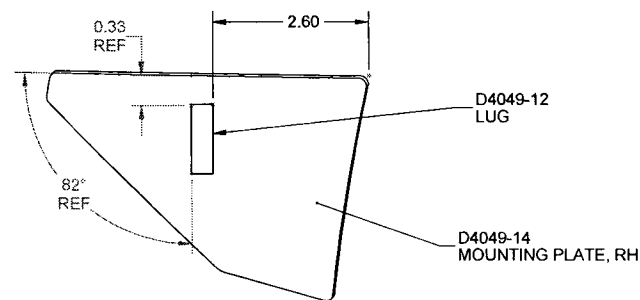
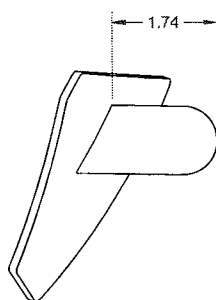
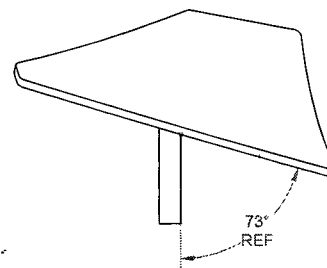
8 7 6 5 4 3 2 1

D

C

B

A



8 D4049-142 MOUNTING LUG ASSY, RH

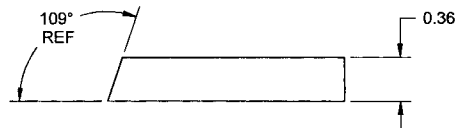
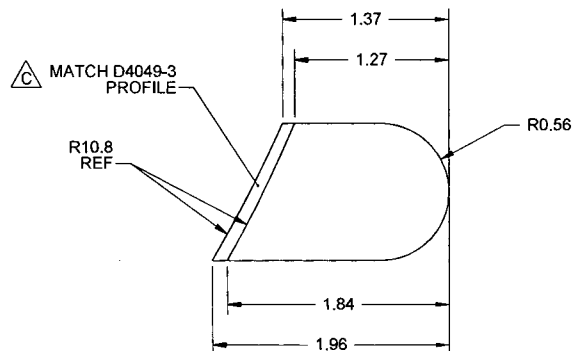
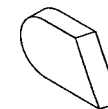
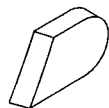
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-142" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.77 lbs
- 8) WELD PER DART QSI 004 USING WELDING JIG DTXXXX

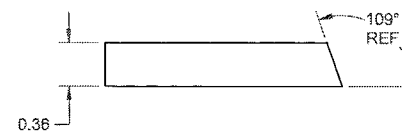
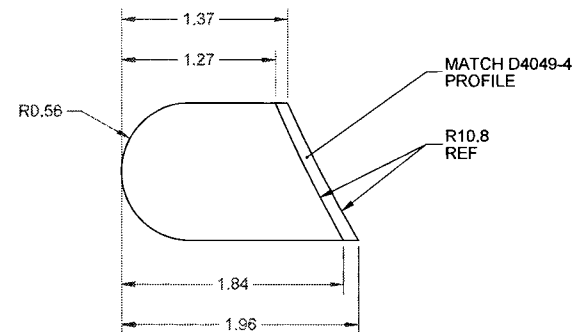
PRELIMINARY ISSUE

DESIGN	VS	<b>DART AEROSPACE LTD</b>	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C1
MFG. APPR.	DD	D4049	SHEET 6 OF 12
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG ASSY	NTS
DATE	15.05.26	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1



**D4049-1 LUG**



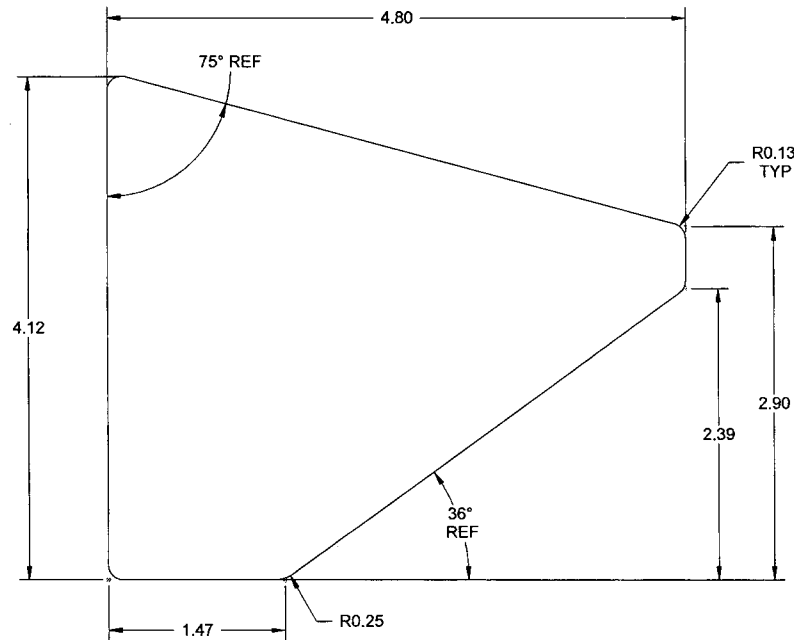
**D4049-2 LUG**

**NOTES:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL BAR  
REF DART SPEC M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.17 lbs

PRELIMINARY ISSUE

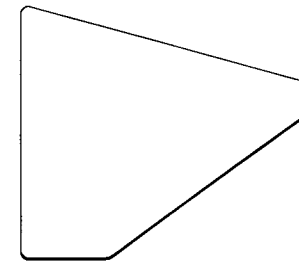
DESIGN	VS	<b>DART AEROSPACE LTD</b>	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C1
MFG. APPR.	DD	<b>D4049</b>	SHEET 7 OF 12
APPROVED		TITLE	SCALE
DE APPR.		<b>MOUNTING LUG ASSY</b>	NTS
DATE	15.05.26	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



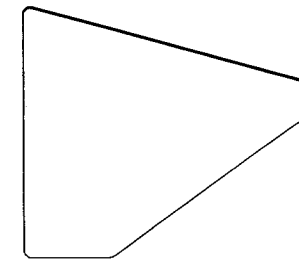
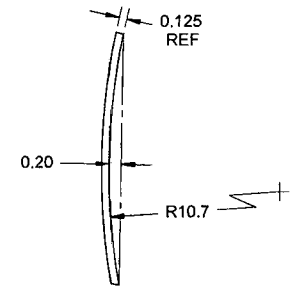
**D4049-3F FLAT PATTERN**

**NOTES:**

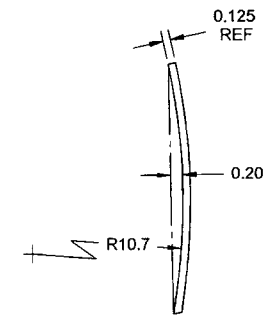
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH, 0.125" THICK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
PER DART SPEC M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.46 lbs



**D4049-3 MOUNTING PLATE, LH**  
(MAKE FROM D4049-3F FLAT PATTERN)



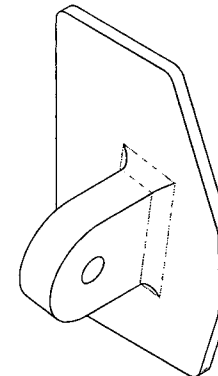
**D4049-4 MOUNTING PLATE, RH**  
(MAKE FROM D4049-3F FLAT PATTERN)



PRELIMINARY ISSUE

DESIGN	VS	<b>DART AEROSPACE LTD</b>	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C1
MFG. APPR.	DD	<b>D4049</b>	SHEET 8 OF 12
APPROVED		TITLE	SCALE
DE APPR.		<b>MOUNTING LUG ASSY</b>	NTS
DATE	15.05.26	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



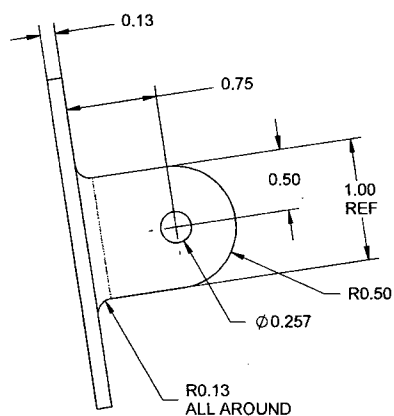


**NOTES:**

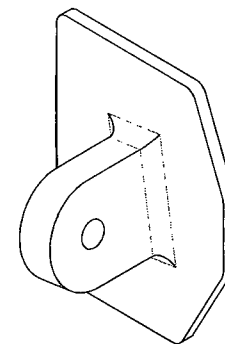
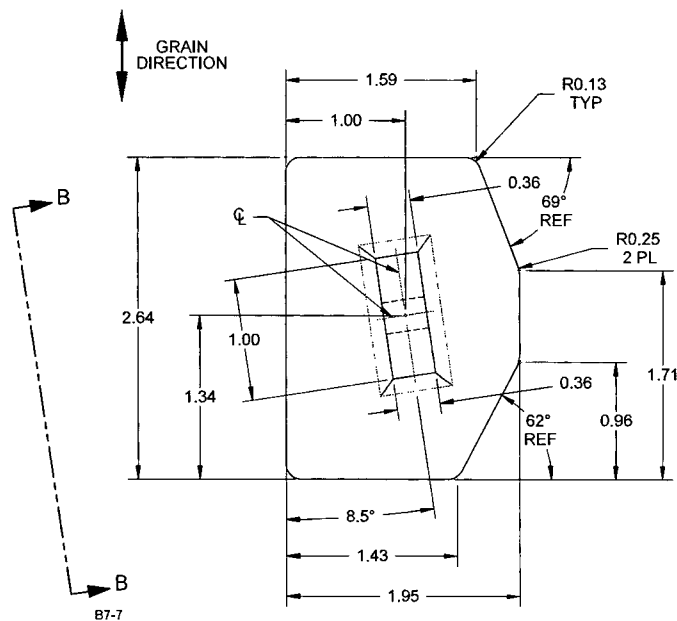
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
AMS-QQ-A-225/8 OR AMS-QQ-A-200/8 OR ASTM B211 OR B221  
PER DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.10 lbs

PRELIMINARY ISSUE

DESIGN	VS	<b>DART AEROSPACE LTD</b>	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	<b>D4049</b>	SHEET 9 OF 1
APPROVED		TITLE	SCALE
DE APPR.		<b>MOUNTING LUG ASSY</b>	NT
DATE	15.05.26	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	



**VIEW B-B** B5-7



**D4049-8 MOUNTING LUG, RH**

**NOTES:**

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
AMS-QQ-A-225/8 OR AMS-QQ-A-200/8 OR ASTM B211 OR B221  
PER DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-8" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.10 lbs

PRELIMINARY ISSUE

DESIGN	VS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO. <b>D4049</b>	REV. C1
MFG. APPR.	DD		SHEET 10 OF 12
APPROVED		TITLE <b>MOUNTING LUG ASSY</b>	SCALE NTS
DE APPR.		<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DATE	15.05.26		

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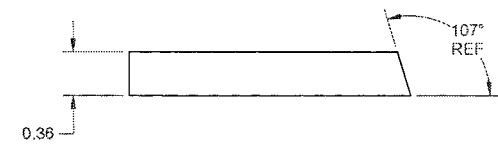
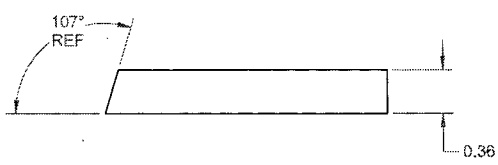
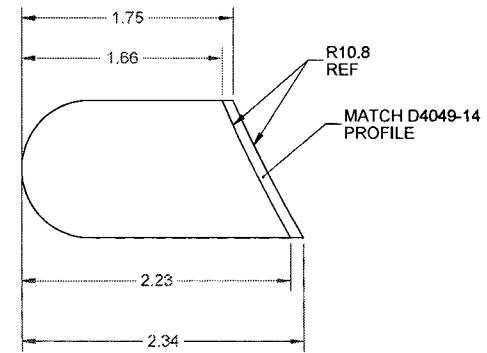
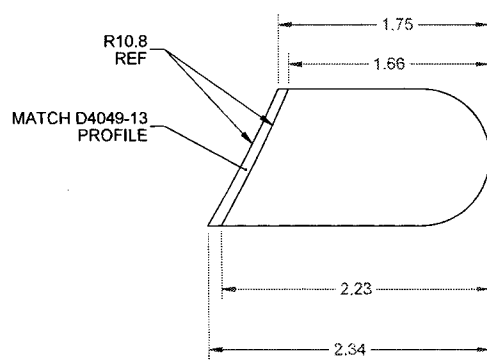
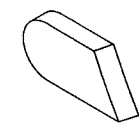
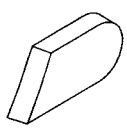
C

B

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A



**D4049-11 LUG**

**D4049-12 LUG**

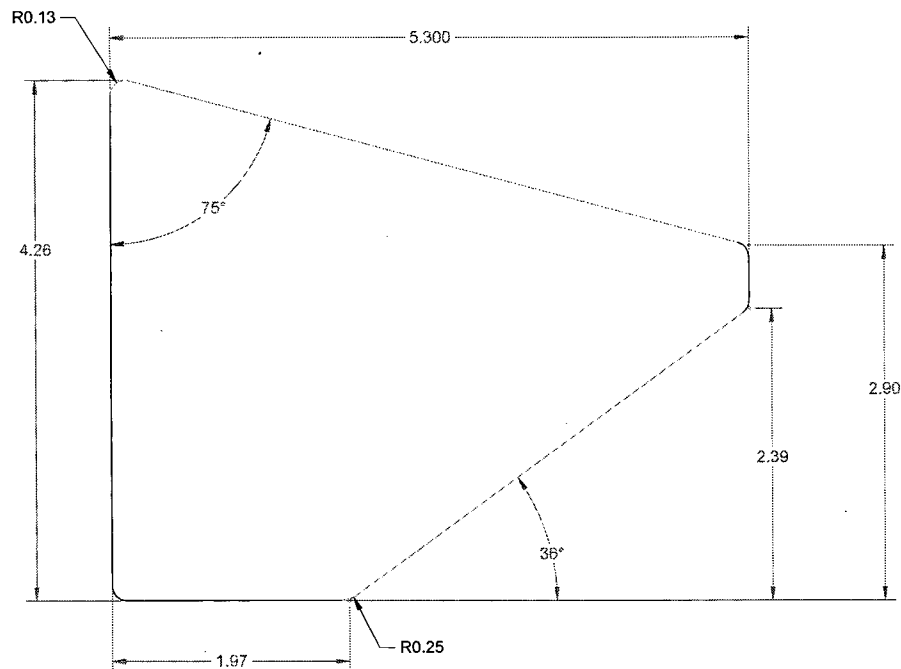
**NOTES:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL BAR  
REF DART SPEC M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.22 lbs

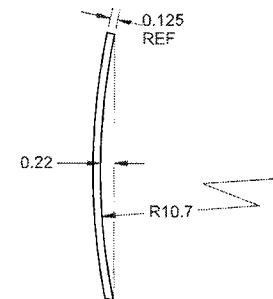
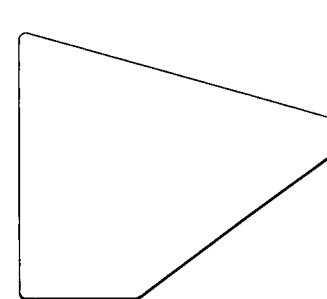
PRELIMINARY ISSUE

DESIGN	VS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. C1
MFG. APPR.	DD	<b>D4049</b>	SHEET 11 OF 12
APPROVED		TITLE	SCALE
DE APPR.		<b>MOUNTING LUG ASSY</b>	NTS
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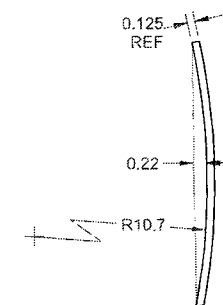
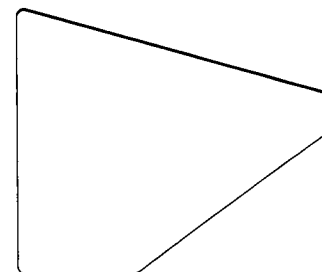
8 7 6 5 4 3 2 1



**D4049-13F FLAT PATTERN**



**D4049-13 MOUNTING PLATE, LH**   
(MAKE FROM D4049-13F FLAT PATTERN)



**D4049-14 MOUNTING PLATE, RH**   
(MAKE FROM D4049-13F FLAT PATTERN)

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH, 0.125" THICK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
PER DART SPEC M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.56 lbs

PRELIMINARY ISSUE

DESIGN	VS	<b>DART AEROSPACE LTD</b>	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C1
MFG. APPR.	DD	<b>D4049</b>	SHEET 12 OF 12
APPROVED		TITLE	SCALE
DE APPR.		<b>MOUNTING LUG ASSY</b>	NTS
DATE	15.05.26	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____		<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube <input type="checkbox"/></td> <td style="border: none;">Cross tube <input type="checkbox"/></td> <td style="border: none;">Water Jet <input type="checkbox"/></td> <td style="border: none;">Engineering <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Machining <input type="checkbox"/></td> <td style="border: none;">Small Fab <input type="checkbox"/></td> <td style="border: none;">Prod. Eng. Coord. <input type="checkbox"/></td> <td style="border: none;">Quality <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Thermoforming <input type="checkbox"/></td> <td style="border: none;">Finishing <input type="checkbox"/></td> <td style="border: none;">Rec/Store/Packaging <input type="checkbox"/></td> <td style="border: none;">Other <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Large Fab <input type="checkbox"/></td> <td style="border: none;">Composite <input type="checkbox"/></td> <td style="border: none;">Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Cross tube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Cross tube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>																						
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>																						
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>																						
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment <input type="checkbox"/> Design <input type="checkbox"/> Doc/Data <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Handling/Pre <input type="checkbox"/> Material <input type="checkbox"/> Internal Transport <input type="checkbox"/> Tribal Knowledge <input type="checkbox"/> LOA <input type="checkbox"/> Substation <input type="checkbox"/> Past Expiry Date <input type="checkbox"/> Misidentified <input type="checkbox"/>	No Re-verification <input type="checkbox"/> Operator <input type="checkbox"/> Offset/Setup <input type="checkbox"/> Supplier <input type="checkbox"/> Training <input type="checkbox"/> Use for Testing <input type="checkbox"/> Poor Information <input type="checkbox"/> Rushing <input type="checkbox"/> Product Improvement <input type="checkbox"/> Process Improvement <input type="checkbox"/> Manufacturing Process <input type="checkbox"/> Past Due <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Wave/Twist in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/>		Temperature/Cure <input type="checkbox"/> Set-up <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Drill Holes <input type="checkbox"/>		Power Loss/Surge <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Off-set <input type="checkbox"/> Misabeled <input type="checkbox"/> Fit/Function <input type="checkbox"/> Misaligned/off center <input type="checkbox"/>		Positioned Wrong <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Misread <input type="checkbox"/> Turning Sequence <input type="checkbox"/>																	
OTHER : _____																									